

Ship 29/12

Work Order ID 77772

77772

Page 1

December-21-11 9:30:18 AM

Item ID: D119-756-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 21/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 06/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/12 Tooling: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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N/A	Rev C
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SP

100 DOCUMENT CONTROL 0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD119-756-011

CHG001

SP 12/12/20

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

SP 11-12-23

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

SP 12/12/20

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Clamp

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Required Date: 06/01/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-756-011								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/01/2011

12/11/23

12-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77772

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Parent Item: D119-756-011

D119-756-011

Parent Item Name: Clamp

Start Date: 21/12/2011

Required Date: 06/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-06-27 JLM
IPP rev B Rev B dwg, picklist 06.07.26 EC
IPP rev C rec C dwg no picklist chg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2617-3 Manufactured No

110

Each

56.0000

2

2

D2617-3

Bushing

**

Location

Loc Qty

Loc Code

FG

10

27991

10

ST019

46

68254

6

76948

40

D2617-5 Manufactured No

110

Each

93.0000

4

4

D2617-5

Spacer

**

Location

Loc Qty

Loc Code

FG

10

31756

10

ST018

60

77502

60

ST019

23

73710

23

D2732 Manufactured No

110

f

357.0700

1.0666

1.122737

D2732

Rubber Extrusion

**

Location

Loc Qty

Loc Code

ST410

357.07

70987

357.07

1- cut 4 pieces at 3.20" as per dwg (D2732-032)

7/11/12
Size 1/2"

1.123x

Sp 11-12-23.

Sp -

2x

Sp

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 77772

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Parent Item: D119-756-011

D119-756-011

Parent Item Name: Clamp

Start Date: 21/12/2011

Required Date: 06/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3789-1

Manufactured No

110

Each

9.0000

1

1

D3789-1

Clamp

**

SP.

Location

Loc Qty

Loc Code

ST462

9

72547

9

D3789-3

Manufactured No

110

Each

1.0000

1

1

D3789-3

Clamp

**

SP.

Location

Loc Qty

Loc Code

ST462

1

51194

1

D3789-5

Manufactured No

110

Each

0.0000

1

1

D3789-5

Clamp

**

B77774 SP

12-01-20

D3789-7

Manufactured No

110

Each

1.0000

1

1

D3789-7

Clamp

**

SP.

Location

Loc Qty

Loc Code

ST462

1

51196

1

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

4

4

AN960JD416

Washer

**

M 119075

SP.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D119-756-011

D119-756-011

Parent Item Name: Clamp

Start Date: 21/12/2011

Required Date: 06/01/2012

Start Qty: 1.00

Required Qty: 1.00

S MS21042L4
MS21042L 4
Nut

Purchased No 110 Each 9,077.000 4 4
**

SP.

Location	Loc Qty	Loc Code
ST300	9077	
117441	51	
117601	342	
118451	133	
<u>119017</u>	3551	
119075	5000	

4x

S AN4-24A
AN4-24A
Bolt

Purchased No 110 Each 57.0000 2 2
**

SP.

Location	Loc Qty	Loc Code
ST359	57	
<u>117514</u>	57	

2x

S AN4-22A
AN4-22A
Bolt

Purchased No 110 Each 188.0000 2 2
**

SP 11-12-23.

Location	Loc Qty	Loc Code
ST359	188	
116419	49	
<u>117313</u>	39	
118628	100	

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

7.0 PARTS LIST

Qty -041	Qty -011	Qty -013	Qty -015	Part Number	Description
X				D119-756-041	HELI-UTILITY-BASKET™
1	X			D119-756-011	CLAMP KIT
		X		D119-756-013	QUICK RELEASE KIT
			X	D119-756-015	CARGO RESTRAINT KIT
2				D2022-101	* SPACER
1				D2258-146	PLACARD (AW119MKII)
1				D2258-154	PLACARD (EASA AIRCRAFT ONLY)
1				D2258-176	PLACARD (A119)
1				D2332-041	* PROP ASSEMBLY
1				D2530	* HANDLE ASSEMBLY
2				D2535	* SPRING
2				D2537	* BUSHING
2	2			D2617-3	BUSHING
4	4			D2617-5	BUSHING
	4			D2732-032	RUBBER CUSHION
2				D2931	* BUMPER
	1			D3789-1	CLAMP
	1			D3789-3	CLAMP
	1			D3789-5	CLAMP
	1			D3789-7	CLAMP
1				D3515-041	* BASKET LID ASSEMBLY
1				D3516-041	* BASKET BASE ASSEMBLY
2				D3516-11	CLEVIS
2				D3517-1	STRUT
2				D3519-1	* PLACARD
1				D3519-3	PLACARD (EASA AIRCRAFT ONLY)
2				D3518-041	STRUT ASSEMBLY
2				D3520-1	SPACER
2				D3520-3	SPACER
2				D3757-1	BLANKING PLATE
			3	D4295-041	STRAP ASSEMBLY

* indicates that part is pre-assembled on basket for customer

REFERENCE ONLY

Qty -041	Qty -011	Qty -013	Qty -015	Part Number	Description
X				D119-756-041	HELI-UTILITY-BASKET™
1	X			D119-756-011	CLAMP KIT
		X		D119-756-013	QUICK RELEASE KIT
			X	D119-756-015	CARGO RESTRAINT KIT
6				AN3-10A	* BOLT
2				AN3-16A	* BOLT
2				AN4-7A	* BOLT
2				AN4-13A	BOLT
6				AN4-15A	BOLT
2				AN4-20A	BOLT
1	2			AN4-22A	* BOLT
1	2			AN4-24A	* BOLT
2				AN5-10A	BOLT
4				AN5-17A	* BOLT
2				AN960JD416	* WASHER
40	4			AN960JD416	WASHER
2				AN960JD416L	* WASHER
4				AN960JD416L	WASHER
4				AN960JD516	* WASHER
2				AN960JD516L	WASHER
2				AN960JD8	* WASHER
12				AN960JD10	* WASHER
4				AN970-4	* WASHER
		4		BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2				MS20600AD4W3	* RIVET
8				MS21042L3	* NUT (OR MS21042-3)
4				MS21042L4	* NUT (OR MS21042-4)
10	4			MS21042L4	NUT (OR MS21042-4)
4				MS21042L5	* NUT (OR MS21042-5)

* indicates that part is pre-assembled on basket for customer